

Work Order ID 150406

Monday, October 24, 2016 7:54:02 AM

150406

Page 1

Item ID: D206-559-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206L Series / 407 Bearpaws

Start Date: 8/12/2016 Start Qty: 7.00

7

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: OCT 24 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

DAS
6
9-89

OCT 24 2016

DAS
21
9-8916-10-24
7

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

TX DAS
27
9-89

NOV 01 2016

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

TX

DAS
26
9-89
DAS
28
9-89

OCT 27 2016

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.04

Quality Control

TX DAS
27
9-89

NOV 01 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 150406

Monday, October 24, 2016 7:54:02 AM

150406

Page 2

Item ID: D206-559-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Series / 407 Bearpaws

Start Date: 8/12/2016 Start Qty: 7.00

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Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013

LOCATION: FG013X
DAS
27
9-89

NOV 01 2016

190

0.00

190

QC

QC21- Final Inspection - Work Order Release

Memo

0.12

Quality Control

DAS
21
9-89

NOV 01 2016

DAS
21
9-89

NOV 01 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 150406

Parent Item: D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

150406

D206-559-013

Start Date: 8/12/2016

Required Date: 8/24/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:J04.02.17Blank size changedKJ/JLM
IPP Rev:K 07-01-02 Was K10008 JLM
IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A		Purchased	No			160	Each	68.0000	12	84			
---------	--	-----------	----	--	--	-----	------	---------	----	----	--	--	--

AN4-17A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST343

68

M135464

18

M135671

50

AN4-20A		Purchased	No			160	Each	69.0000	12	84			
---------	--	-----------	----	--	--	-----	------	---------	----	----	--	--	--

AN4-20A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

6

m116419

6

ST343

63

m135056

13

m135600

50

D2182B		Manufactured	No			160	f	276.5400	2.5	17.5			
--------	--	--------------	----	--	--	-----	---	----------	-----	------	--	--	--

***D2182B*-050**

Rubber Cushion - Black (\$Per Foot)

6x 5" per kit

DAS
27
9-89

Location

Loc Qty

Loc Code

ST411

276.54

135093

276.54

DAS DAS
28 28
9-89 9-89
m135966.16x

18x
50

DAS DAS
28 28
9-89 9-89
m135966x38

46x

DAS DAS
28 28
9-89 9-89
B13515520

17.5

OCT 27 2016



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Work Order ID: 150406

150406

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 8/12/2016

Required Date: 8/24/2016

Start Qty: 7.00

Required Qty: 7.00

D2274

Manufactured No

160 Each

281.0000

12 84

D2274

Radius Block

**

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	12	
86855	12	
ST006	269	
150353	114	
150676	155	

DAS
27
9-89

D2432

Manufactured No

160 Each

28.0000

2

D2432

Bearpaw 19" X 24"

**

13x
71x
14
OCT 24 2016

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST	26	
151377	12	
151771	14	
ST430A	2	
147544	1	
150373	1	

DAS
27
9-89

D2438

Manufactured No

160 Each

71.0000

6

D2438

Clamp

**

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST542	71	
147538	1	
150365	30	
151376	40	

DAS
27
9-89

1x
30
11x

OCT 27 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, October 24, 2016 7:54:07 AM

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Work Order ID: 150406

150406

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 8/12/2016

Required Date: 8/24/2016

Start Qty: 7.00

Required Qty: 7.00

D2529

Manufactured No

160 Each

683.0000 12 84

D2529

Washer

**

DAS
26
9-89
28
9-89

OCT 26 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008 683
150080 500
150996 183

D2732

Manufactured No

160 f

515.2313 2.5 17.5

***D2732* -650**

Rubber Cushion (\$per foot)

**

53x
34x

B150002

DAS
26
9-89

DAS
28
9-89

OCT 26 2016

6x5" per kit

DAS
27
9-89

Location

Loc Qty

Loc Code

ST412 515.2312605
117118 5E-10
143793 15.2312605
150042 500

MS21042L4

Purchased No

160 Each

2,294.000 12 84

MS21042L4

Nut

**

DAS
26
9-89
28
9-89

OCT 26 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001 34
m133363 34
GA 260
m135058 260
OVER007 1500
m135774 500
m135864 1000
ST303 500
m135704 500

84x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
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Page 4

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Parent Item: D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

150406

D206-559-013

Start Date: 8/12/2016

Required Date: 8/24/2016

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0463J

Purchased

No

160

Each

2,310.000

24

168

**

NAS1149D0463.J

Washer

DAS
26
9-89
2
9-8

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

135

M134508

32

M135056

103

ST260a

1000

M135767

1000

ST263

1175

M135530

175

M135671

1000

OCT 26 2016

168x.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP